

Work Order ID 48567

June 26, 2009 5:51:50 PM



Page 1

Item ID: K10003
Revision ID: F
Item Name: Saddle, D205-634-011

Accept



Setup Start
Stop



Start Date: 15/07/2009 Start Qty: 5.00
Required Date: 03/08/2009 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN634,635	Rev F

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Create White labels only per PPP K10003

CHG 006

for CL 09/06/29

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

*for 05.29 (5)
@ chg 007*

Work Order ID 48567

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Page 2

Item ID: K10003
Revision ID: F
Item Name: Saddle, D205-634-011

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 5.00
Required Date: 03/08/2009 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:
QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: *RK*

0.00

Memo

9/6/29
SP *(SX)*

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Lawd
09/07/09
MF 09-07-08

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Page 1

Parent Item: K10003RevF

Parent Item Name: Saddle, D205-634-011

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 5.00

Required Qty: 5.00

[illegible]

Picklist Print

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Page 2

Work Order ID: 48567

Parent Item: K10003RevF

Parent Item Name: Saddle, D205-634-011



















Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2573RevE  Saddle, Aft Out 205	2	Manufactured	No				Each 1	25.0000	5.0000 	B48354	08/06/29	XS
✓ D2574RevE  Saddle, Aft In 205	2	Manufactured	No				Each 1	12.0000	5.0000 	B48355	08/06/29	
✓ D2747RevB  Set Screw	2	Manufactured	No				Each 4	305.0000	20.0000 	B43855	08/06/29	XS
✓ D2876RevB  Saddle Spacer	2	Manufactured	No				Each 2	238.0000	10.0000 	B42364	08/06/29	XS
✓ D2877RevB  Saddle Spacer	2	Manufactured	No				Each 2	179.0000	10.0000 	43857	08/06/29	XS
✓ D3405-041RevB  Lug Assembly	2	Manufactured	No				Each 1	27.0000 041	5.0000 	47200	08/06/29	XS
✓ D3405-043RevB  Lug Assembly	2	Manufactured	No				Each 1	28.0000 043	5.0000 	B47308	08/06/29	XS
✓ D3407-041RevE  Tow Ring	2	Manufactured	No				Each 1	28.0000	5.0000 	B47309 x4 B48356 x4	08/06/29	XS
✓ D3417-5RevD  Washer	2	Manufactured	No				Each 2	33.0000	10.0000 	B45916	08/06/29	XS

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 48567

Parent Item: K10003RevF

Parent Item Name: Saddle, D205-634-011

Comments:



Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3456-1RevA 		Manufactured	No				Each 1	70.0000	5.0000		B46752	2809/06/29 (x5)
✓ Washer D3533-1RevB 		Manufactured	No				Each 2	110.0000	10.0000		B47625 x 2 B44644 x 8	2809/06/29 (x5)
✓ Set Screw MS21042L4 		Purchased	No				Each 24	9,086.000	120.0000		M110507	2809/06/29 (x5)
✓ Nut MS21043-4 		Purchased	No				Each 5	276.0000	25.0000		M111819	2809/06/29 (x5)
Nut												

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Shop Packet Print

Page 3

Date: Friday, 12/06/2009 9:59:53 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT
Job Number : 48567	
Estimate Number : 10532	
P.O. Number :	Part Number : K10003
This Issue : 12/06/2009 S.O. No. :	Drawing Number : 634, 635 IIN
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 48264	Material :
Written By :	Due Date : 23/06/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 JLM Est : K 06.11.17 Per K10003 Rev C KJ Est : L 07.01.12 Document Record for copying bluefile rmv KJ Est Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by: Est N 09.01.27 DSI 9418 rev B EC verified by: DD Est P 09.04.20 fixed pick list EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 007 ✓

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2570 ✓	Bushing
-----	---------	---------

**Comment:** Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	



4.0	D2571 ✓	Saddle, Fwd Out 205
-----	---------	---------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:59:53 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 48567

Part Number: K10003

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D2572 ✓	Saddle, Fwd In 205
-----	---------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	



6.0	D2573 ✓	Saddle, Aft Out 205
-----	---------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	



7.0	D2574 ✓	Saddle, Aft In 205
-----	---------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	



8.0	D3405041 ✓	Lug Assembly
-----	------------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

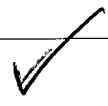


9.0	D3405043 ✓	Lug Assembly
-----	------------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly



10.0	D2747 ✓	Set Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:59:53 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 48567

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 D2876 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	

12.0 D2877 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	

13.0 D35331 Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Set Screw

Batch:

14.0 AN46A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

15.0 AN4C47A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

batch:

16.0 AN451A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:59:53 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 48567

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN612A ✓

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	



18.0

AN960JD416 ✓

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 192.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	



19.0

AN960JD616 ✓

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	



20.0

MS21042L4 ✓

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Nut

Batch: _____



21.0

D3407041 ✓

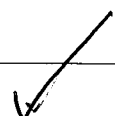
Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Tow Ring

batch: _____



22.0

D34561 ✓

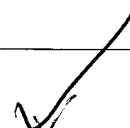
Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch: _____



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:59:53 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 48567

Part Number: K10003

Job Number:



Seq. #:	Machine Or Operation:	Description :
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23.0	MS210434 ✓	Nut
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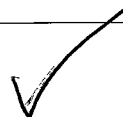
Comment: Qty.: 5.0000 Each(s)/Unit Total : 30.0000 Each(s)
Nut
batch: _____



24.0	D34175 ✓	Washer
------	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer
batch: _____



25.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT KITS 100% FOR COMPLETENESS



26.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____



27.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F
 Date: 08.10.07
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 1850

5.0 D204-635-011 SKIDTUBE INSTALLATION PARTS LIST

Item	635 -011	635 -041	641 -011	Part Number	Description
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT
1		1		D2590-041	204 SKIDTUBE ASSEMBLY
2A		10		D2594-1	* PLUG
2B		10		D2594-3	* O-RING
3		1		D2855	* AFT CAP
4		2		AN3-5A	* BOLT
5		2		AN960JD10L	* WASHER
6A		1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B		1		D3566-1	* GASKET
7A		1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B		1		D3566-1	* GASKET
8A		1		D3564-7	* WEARSHOE (REPLACES D2577-7)
8B		1		D3566-7	* GASKET
9A		1		D3564-13	* WEARSHOE
9B		1		D3566-13	* GASKET
10		44		AN3C4A	* BOLT (REPLACES AN3-4A)
11		44		AN960C10L	* WASHER (REPLACES AN960JD10L)
12		44		ALS4-1032-130	* INSERT
13		2		ALS4-1032-225	* INSERT
20	1			D2571	SADDLE, FWD OUTSIDE
21	1			D2572	SADDLE, FWD INSIDE
22	1			D2573	SADDLE, AFT OUTSIDE
23	1			D2574	SADDLE, AFT INSIDE
24	8			AN4-51A	BOLT
25	16			D2570	BUSHINGS
26	8			MS21042L4	NUT (OR MS21042-4)
27	8			AN6-12A	BOLT
28	8			AN960JD616	WASHER
29	16			AN4-6A	BOLT
30	32			AN960JD416	WASHER
31	16			MS21042L4	NUT (OR MS21042-4)
32	4			D2747	SET SCREW
33	2			D3533-1	SET SCREW
40	1			D3407-041	TOW RING ASSEMBLY (REPLACES D2968-041)
41	1			D3456-1	WASHER
43	1			MS21043-4	NUT
44	2			D3417-5	WASHER
50			1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51			1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52			4	AN4C47A	BOLT
53			8	D2570	BUSHING
54			4	MS21043-4	NUT
60	2			D2876	SADDLE SPACER
61	2			D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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RETURN TO

ENGINEERING

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Revision: EFFECT TO AMENDMENT

Date: 08/10/07 NOTICE

WORK ORDER

NO. 2856